

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010718**Date Inspected:** 08-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Tu Jun			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG/ TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

HEAVY DOCK

ULTRASONIC INSPECTION

OBG SEGMENT 4EAST

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the bottom panel splice weld between OBG segment 4AE and (OBE4A-003) utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 12072009-2.

No relevant indications were found.

BAY # 10

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector randomly observed the following work in progress.

SOUTH TOWER LIFT # 4

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 054069 performing Flux Cored Arc Welding process for the weld SSTL4-1K/L located on PCMK fit lug at top of 143m double diaphragm. ZPMC QC Mr. Tu Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

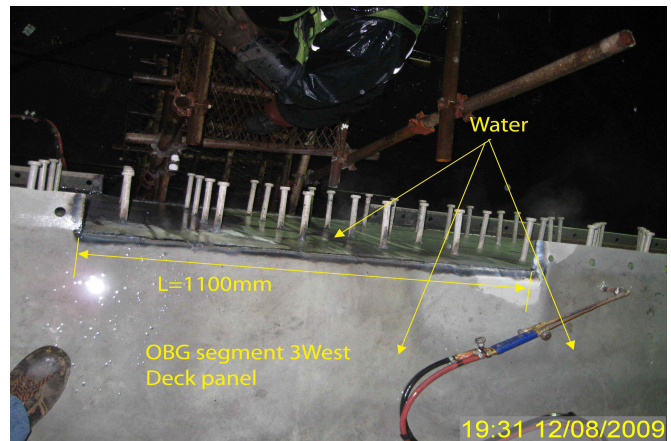
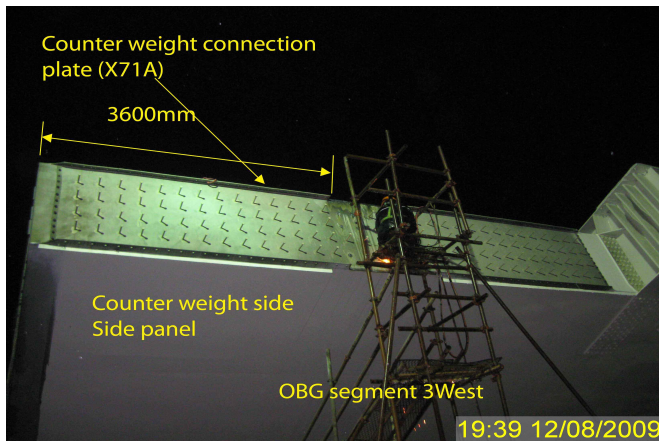
This Quality Assurance (QA) Inspector observed ZPMC qualified welder 221825 performing Flux Cored Arc Welding process for the weld SSTL4-1J/L located on PCMK fit lug at top of 139m double diaphragm. ZPMC QC Mr. Tu Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

HEAVY DOCK

OBG SEGMENT 3AW

This Quality Assurance Inspector observed ZPMC personnel performed free hand thermal cutting on the counter weight connection plate at PP23 of OBG segment 3AW prior to obtaining Engineering approval. The length of free hand cut was approximately 1100mm and was located 3600mm from the end the segment. For additional information see attached photos. Note: This cutting process was going on in the bad weather conditions (during rain). The incident report was generated for this issue.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer